

Work Order ID 48514

June 26, 2009 12:45:40 PM

Page 1

Item ID: D2662-2

Accept

Revision ID: D

Item Name: Saddle, RH In 206

Start Date: 15/07/2009 Start Qty: 6.00

Required Date: 03/08/2009 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2662

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. Inspect part number and batch number are programmed correctly. Fixturing Inspection last completed _____ by _____ Machine Step No 1 of Folio and inspect per attached Dimension Sheet Machine Step No 2 of Folio

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

finishing

old work order
↓

Date: Thursday, 11/06/2009 1:55:00 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 SADDLE, INBOARD, RIGHT SIDE
Job Number	: 48514		
Estimate Number	: 12130		
P.O. Number	:	Part Number	: D26622
This Issue	: 11/06/2009 S.O. No. :	Drawing Number	: D2662 REVD
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: D
Previous Run	:	Material	:
Written By	: <u><i>JLM 09.06.11</i></u>	Due Date	: 18/06/2009
Checked & Approved By	:	Qty:	6 Um: Each
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM		



Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
7075-T7351 2X6X6.25
Issue material from stock: 7075-T7351
Cut Size 2.0 x 6.25 X 6.0 Grain Along
Long 6.0 Length
Batch No: 10409

SR 09/06/14

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
Inspect part number and batch number are programmed correctly.

Fixturing Inspection last completed 09/06/16 by *mmf*

Machine Step No 1 of Folio and inspect per attached Dimension Sheet
Machine Step No 2 of Folio and inspect per attached Dimension Sheet
Machine Step No 3 of Folio and inspect per attached Dimension Sheet
Machine Step No 4 of Folio and inspect per attached Dimension Sheet
Deburr

mmf 09/06/16 SR 09/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2662-Z PAR #: _____ Fault Category: Prod. Machined parts NCR: Yes No DQA: / Date: 05.05.15
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 05.11.25

NCR: <u>48514</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.05.15	Z	AREA ON SKID FLANGE IS 0.020" LOWER THAN REMAINING FLANGE operator error/origin EC. PROY ERROR	CP 05.05.10 P 05.04.2	High stress area. SCRAP PART = replace	CP 09/09/10	/	CP 05.05.15 P 05.04.2	/
09/05/15	Z	Ridge of .250 ± .005" under tolerance. operator EC. PROY ERROR/origin.	↓	↓	CP 09/06/15	/	↓	/
05.06.10	Z	WALL THICKNESS AT DIM "J" IS UP TO 0.137". R.C. operator error / off set	CP 05.06.16 P 05.04.2	WALL THICKNESS UP TO 0.140" OK AT THIS LOCATION.	mm5= 09/06/16	/	CP 05.06.17 P 05.04.2	/

NOTE: Date & initial all entries → LCA

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 SADDLE, INBOARD, RIGHT SIDE

Job Number: 48514

Part Number: D26622

Job Number:



Seq. #: Machine Or Operation: Description :

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

09/06/22
H.A.

SF 09/06/23

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SF 09/06/23

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SL 09/06/24

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

LMD 09/06/24

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 2:15pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 2:45pm

JL 09-06-24 (X6)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

R 9/8/27

(6)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 435

R 9/5/18 (6)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/09/08

Job Completion

POSITIVE RECALL
EFFECTIVE 09/06/12 AUTH/L
RELEASED 4 DATE 09/09/08

DART AEROSPACE LTD	Work Order: 48514
Description: 206 Saddle, Inboard, Right side	Part Number: D2662-2
Inspection Dwg: D2662 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	1 2	2 3	3 4		
A	0.100	0.140		.110	.109	.107	.108		
B	0.100	0.140		.135	.140	.136	.137		
C	1.125	1.145		1.140	1.136	1.136	1.135		
D	0.615	0.685		.675	.672	.677	.670		
E	0.240	0.260		.253	.250	.247	.248		
F	1.313	1.343		1.340	1.318	1.319	1.318		
G	0.210	0.230		.225	.230	.225	.227		
H	0.100	0.180		.132	.125	.127	.130		
I	2.470	2.510		2.493	2.486	2.483	2.497		
J	1.565	1.585		1.575	1.573	1.574	1.574		
K	0.235	0.240		.235	.235	.235	.235		
L	0.100	0.120		.110	.110	.110	.110		
M	0.990	1.010		1.005	1.006	1.001	1.004		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.001	6.001	6.001	6.001		
P	1.245	1.255		1.248	1.249	1.250	1.250		
Q	2.495	2.505		2.500	2.499	2.498	2.500		
R	0.313	0.318		.316	.316	.316	.316		
S	0.315	0.322		.316	.316	.316	.316		
T	2.495	2.505		2.500	2.497	2.497	2.497		
U	1.357	1.367		1.361	1.360	1.360	1.360		
V	0.787	0.807		.794	.792	.792	.793		
W	0.540	0.560		.550	.540	.545	.545		
X	1.674	1.684		1.678	1.678	1.678	1.678		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.924	.925	.925	.925		
AA	0.490	0.510		.500	.498	.498	.501		
AB	0.178	0.198		.183	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	mmf
Date:	09/06/16

Audited by:	JL
Date:	09/06/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD		Work Order: 48514
Description: 206 Saddle, Inboard, Right side		Part Number: D2662-2
Inspection Dwg: D2662 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance		Actual Dimension	Accept ⁵	Reject ⁶	Method of Inspection	Comments
	Min	Max					
A	.100	.140	.109	.109	.109		
B	.100	.140	.138	.138	.138		
C	1.125	1.145	1.136	1.136	1.136		
D	.615	.685	.680	.683	.680		
E	.240	.260	.249	.250	.250		
F	1.313	1.343	1.318	1.318	1.318		
G	.210	.230	.227	.227	.230		
H	.100	.180	.130	.131	.130		
I	2.470	2.510	2.485	2.490	2.488		
J	1.565	1.585	1.574	1.574	1.574		
K	.235	.240	.235	.235	.235		
L	.100	.120	.110	.110	.110		
M	.990	1.010	1.003	1.003	1.003		
N	.510	.515	.510	.510	.510		
O	6.990	6.010	6.001	6.001	6.001		
P	1.245	1.255	1.250	1.250	1.250		
Q	2.495	2.505	2.500	2.499	2.500		
R	.313	.318	.316	.316	.316		
S	.315	.322	.316	.316	.316		
T	2.495	2.505	2.497	2.498	2.497		
U	1.357	1.367	1.360	1.360	1.361		
V	.787	.807	.792	.794	.794		
W	.540	.560	.540	.542	.543		

Measured by: mmw	Audited by: JJ	Prototype Approval: N/A
Date: 09/06/17	Date: 09/06/24	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

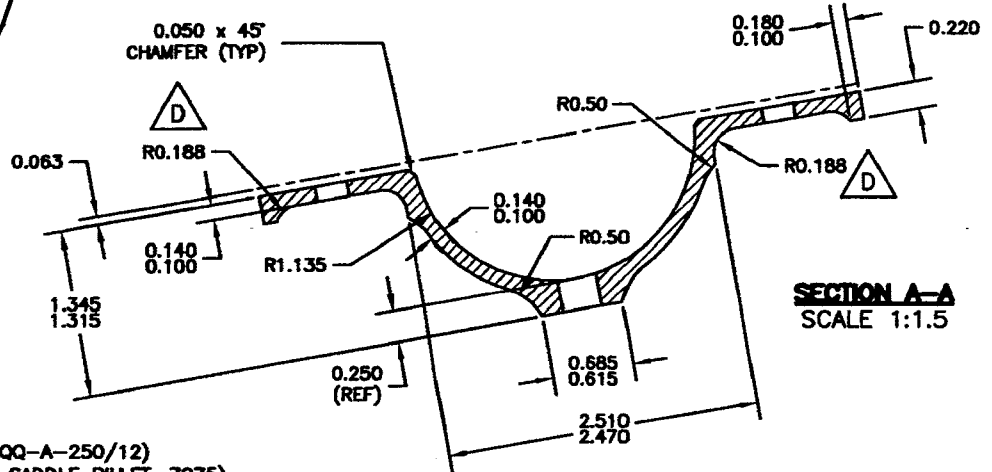
DART

DESIGN A	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2662	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE INSIDE	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORP' DEO 9122/9102/9095/9137	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	

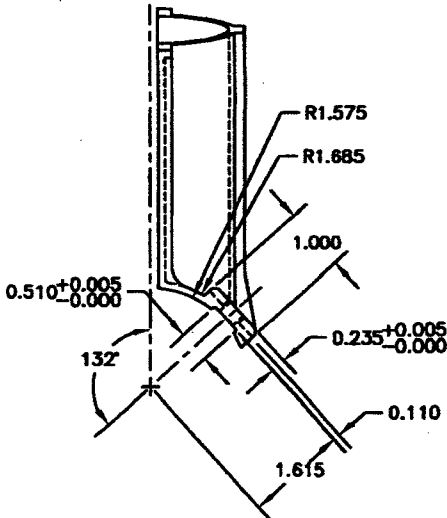
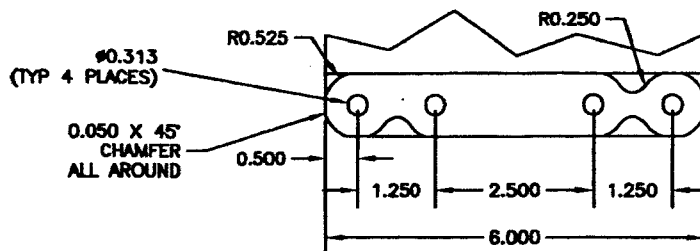
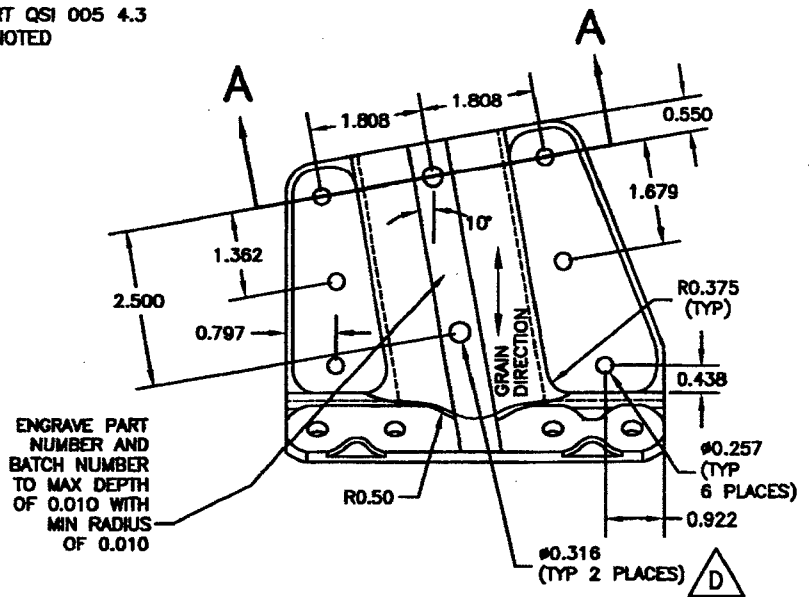
RELEASED

07.02.02

w/o 48514

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) D2662-1 SHOWN (D2662-2 IS OPPOSITE)

**D2662-1 SADDLE INSIDE**

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